

Date: Tuesday, 10/23/2007 3:10:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HEATER BRACKET
Job Number : 35323	
Estimate Number : 12159	
P.O. Number : <u>N/A</u>	Part Number : D2002003
This Issue : 10/23/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2002 REV C
Prsht Rev. : <u>NC</u>	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 28129	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/15/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>10</u> Um: Each
Comment : Est. B 99.05.21 Re-format, Made in house DM	
Est Rev:C Now on Waterjet 06-08-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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4.4913



Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s)

2024-T3 .063 sheet

Material: 2024-T3, 0.063" Thick

Batch 102942B07-11-8M13886 104672

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2002-003

Dwg Rev: CProg Rev: CB07-11-8

2-Deburr if necessary

B07-11-8

(11)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B07-11-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 4/11/09 (x11) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink holes as per Dwg D2002-003

Deburr

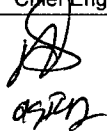

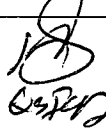

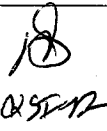
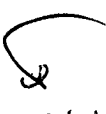
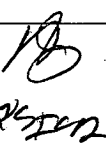

MF 07-11-26

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/28
 QA: N/C Closed: ☒ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/19	5	1 piece crack at the bend R.C. setup (first part)		Scrap & destroy	SB 07/11/19	 07/11/26		
07-11-26	5	1 piece, counter sink hole too big. R.C. human error		Scrap & destroy	MF 07-11-26	 07/11/26		

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER BRACKET

Job Number: 35323

Part Number: D2002003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form as per Dwg D2002-003

SB 07/11/19

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
07/11/26 (9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. 07/11/27

8.0

POWDER COATING

POWDER COATING



Comment: PURCHASING

Powder Coat Black Crinkle (Ref. 4.3.5.3) as per QSI 005 4.3

m 102316

FL 07/11/27 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 07/11/27

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5166

0

B 07/11/28

(9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(9)
D 07/11/28

Job Completion



W 07/11/28

Dart Aerospace Ltd

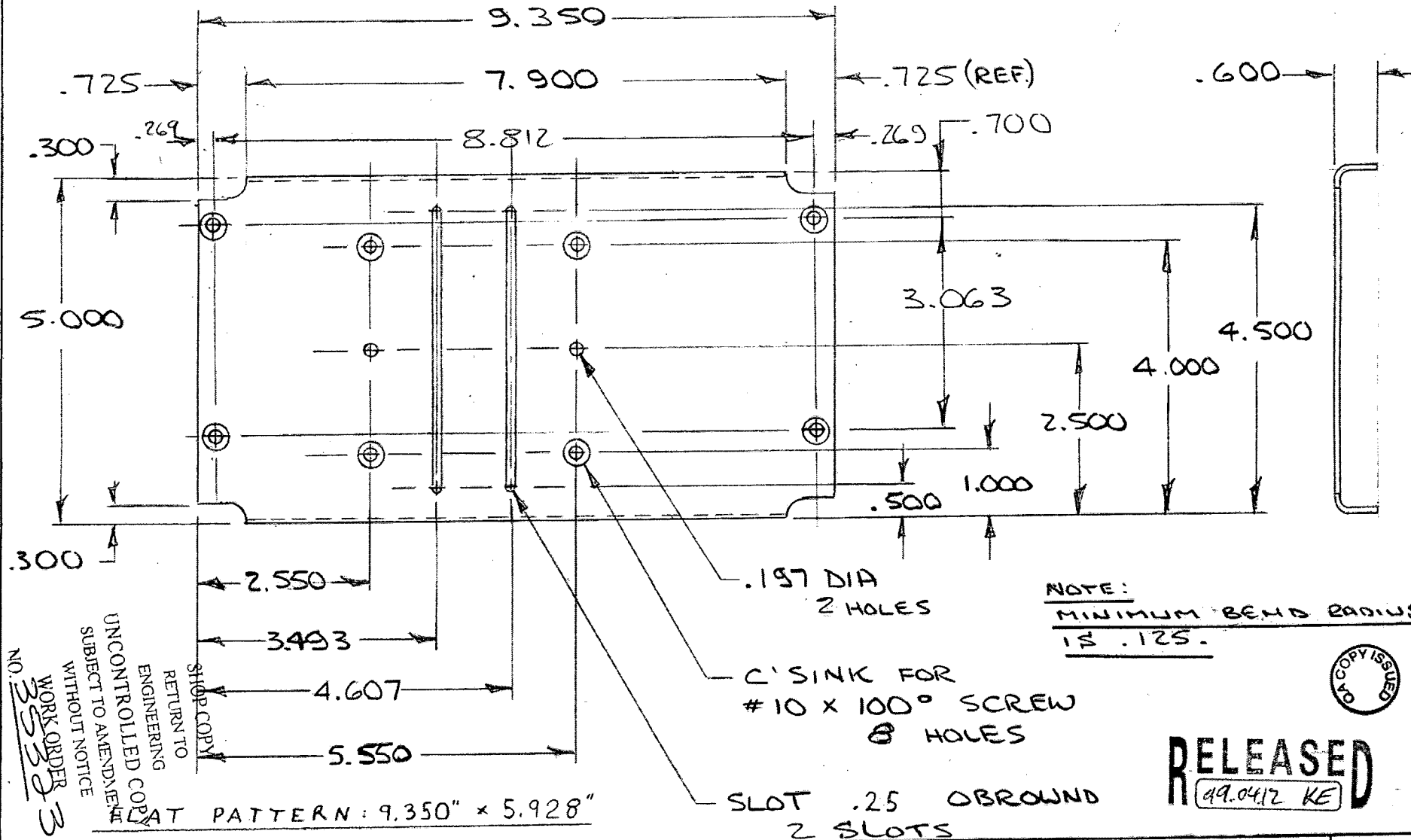
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

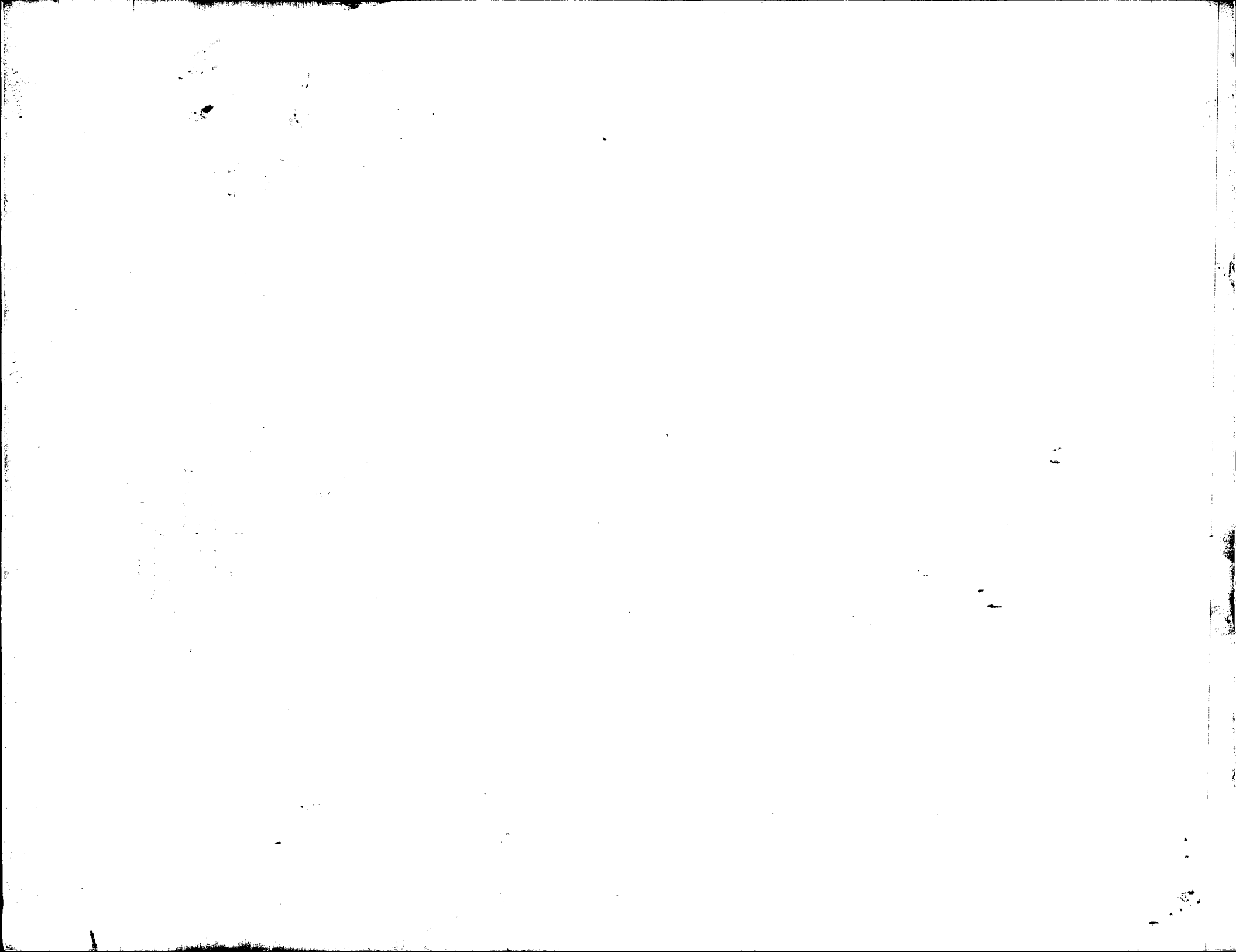
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



C B A		REVISION	RIVET CODE SHALL BE PER NAS 623		D2002-003 BRACKET 2024-T3 X.063 QQ-A-250/5	
KE	JB	DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		PART NO. ITEM DESCRIPTION MATERIAL SPEC/VENDOR	
4/2/72	11/28	APPROVED	BASIC CODE DIA. DASH NO. W-HEAD NEAR SIDE P-HEAD FAR SIDE		CONTRACT NO.	
025 WAS 050 570	025 WAS 050 570		D=DIMPLE DASH-NO OF SHEETS C=COUNTERSINK		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA	
025 WAS 050 570	025 WAS 050 570		BASIC CODES		DRAWN BRADLEY 9/19/10	
025 WAS 050 570	025 WAS 050 570		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 7742 5. HOLES PER ANGLE 10087		DESIGN BRADLEY 9/19/10	
025 WAS 050 570	025 WAS 050 570		1. TOLERANCES - .XX ± .030 .XXX ± .010 2. ANGLES 2 W° 3. PARALLELISM 1 .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		STRESS	
025 WAS 050 570	025 WAS 050 570		REPORT ALL DISCREPANCIES - DO NOT SCALE		TITLE BRACKET	
025 WAS 050 570	025 WAS 050 570				CODE YU D2002-003	
025 WAS 050 570	025 WAS 050 570				SCALE 1:2 SHT 1 OF 1	



DART AEROSPACE LTD		Work Order:	35323
Description: HEATER BRACKET		Part Number:	2002003
Inspection Dwg: D2002003 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .197	+ .005 - .001	.197	x			
9.350	+/- .010	9.350	x			
5.928	+/- .010	5.928	x			
7.900	+/- .010	7.900	x			
8.812	+/- .010	8.812	x			
.725	+/- .010	.728	x			
.500	+/- .010					
1.000	+/- .010					
2.500	+/- .010					
4.000	+/- .010					
4.500	+/- .010					
.269	+/- .010	.269	x			
2.550	+/- .010	2.550	x			
3.493	+/- .010	3.493	x			
4.607	+/- .010	4.607	x			
5.550	+/- .010	5.552	x			
.269	+/- .010	.269	x			
.25	+/- .030	.25	x			
3.063	+/- .010	3.063	x			

Measured by: IB	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: 07-11-8	Date: <i>[Signature]</i>	Date: <i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	